

Date: Wednesday, 2/15/2006 3:50:13 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : EXTRUSION 'I' BEAM TUBE 4"
Job Number : 25858	
Estimate Number : 10154	
P.O. Number : N/A	Part Number : D25001190
This Issue : 2/15/2006 S.O. No. : N/A	Drawing Number : D2500 REV F1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : F1
Previous Run : 24669	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 3/10/2006 Qty: 80 Um: Each
Checked & Approved By : [Signature] 06.02.16	
Comment : Est: 02.09.05 Added DSK 066	KJ/RF

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

PG

PURCHASING

**Comment:** PURCHASING

Issue P/O: 599

- a) Extrude as per Dwg D2500
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 190" long
- g) Bon L Canada Inc. tool # 897105
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

U 06-02-16 80

2.0

D25001190P

Ext'n - 'I' Beam Tube 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 80.0000 Each(s)
 EXTRUSION 'I' BEAM TUBE 4"

3.0

PACKAGING 1

PACKAGING RESOURCE #1

**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure material certification is attached

Rec'd 3/23 (87)

4.0

QC6

DIMENSIONAL CHECK

**Comment:** DIMENSIONAL CHECK

Inspect dimensions per Dwg D2500
 Check Pull test per Dwg D2500 for compliance page attached.
 Check hardness with Webster tester

05-06-12 (87)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/02/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:50:13 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: EXTRUSION 'I' BEAM TUBE 4"

Job Number: 25858

Part Number: D25001190

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

06-06-12 (87)

06/12/06 87

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(87)

06/10/13

Job Completion



u 8606-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DW</i>	DRAWN BY <i>DW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DW</i>	DRAWING NO. D2500	REV. F SHEET 1 OF 2
DATE 97:09:29		TITLE EXTRUSION	SCALE NTS
A	96:03:19	NEW ISSUE	
B	96:03:24	CHANGE INTERNAL WEB	
C	96:04:26	ADD D2500-3 WEB	
D	96:10:07	ADD MATERIAL PROPERTIES	
E	96:10:24	CHANGE MATERIAL TEMPER	
F	97:09:29	CHANGE MAT. TO 6061-T6	
F1	01.04.17	ADD NOTES 4 & 5 <i># UP</i>	

RELEASED
97/10/06 DS

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM TENSILE YIELD STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX

3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

4. FOR D2500-1, PART NUMBER IS D2500-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-1-190 IS 190" LONG)

D2500-1 EXTRUSION MANUFACTURED FROM: a) BON L DIE # B97105 → PREFERRED
b) CARADON MIDEAST DIE # PAH-28030
c) CARADON MTL DIE # MH-18868

5. FOR D2500-3, PART NUMBER IS D2500-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2500-3-100 IS 100" LONG)

D2500-3 EXTRUSION MANUFACTURED FROM CARADON INDEX DIE # *MS-18867*
SUBJECT TO AMENDMENT

WITHOUT NOTICE

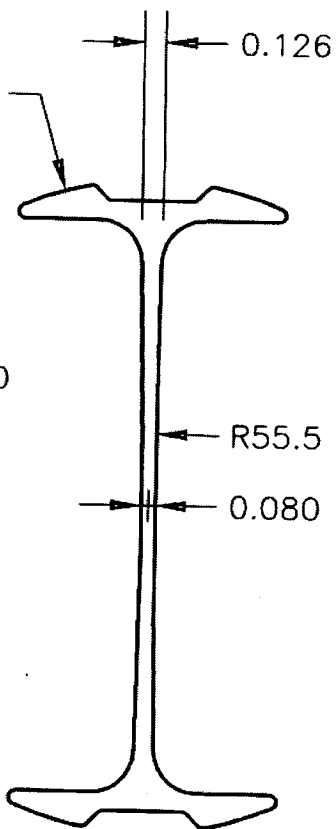
WORK ORDER

NO. *25858*

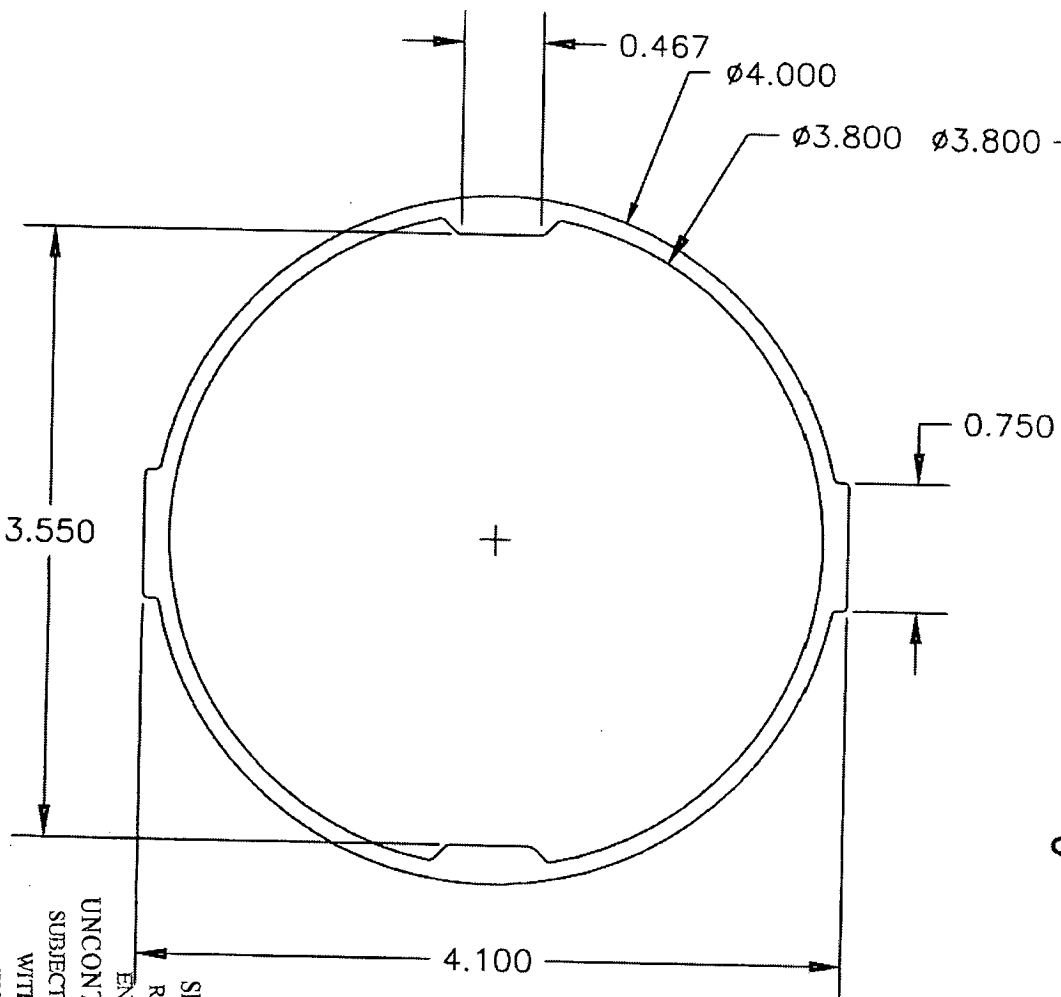


DESIGN <i>MB</i>	DRAWN BY <i>MB</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>FE</i>	APPROVED <i>MB</i>	DRAWING NO. D2500	REV. F
DATE 97:09:29		TITLE EXTRUSION	SHEET 2 OF 2
			SCALE 1:1

RELEASED
47 10 06 05



D2500-3



D2500-1

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 25858



CERTIFICATE OF COMPLIANCE

BON L CANADA INC

1850 CLEMENTS ROAD
PICKERING, ON L1W 3R8

Cert. Date	Cert. No.	Sales Order	Page
03/22/06	136553	89824	1
Cust. PO	B/L No.	Lot	Date
599	00297763	89824010	3/22/06

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897105-2	190" Mill 6061 T6	D2500-1-190
Gross Weight	1129 KGS		
Net Qty	1,105 KG	87 PC	420 M 4 PKG
Specification			Dis Desc
AMS-QQ-A-200/8 & ASTM-B221-00			

Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	282.8 / 41.0	265.7 / 38.6	8.8	.0	94
2	285.5 / 41.4	267.2 / 38.8	8.9	.0	94

Chemical Limits:

	SI	FE	CU	MN	MG	CR	ZN	TI	OTHER
MIN:	.40	.00	.15	.00	.80	.04	.00	.00	EA: .05
MAX:	.80	.70	.40	.15	1.20	.35	.25	.15	TOT: .15

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Conchita Ko, QA Manager Signed for Bon L Canada

Conchita Ko.